

(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets

(11)

EP 1 188 692 A2



(12)

EUROPEAN PATENT APPLICATION

(43) Date of publication:
20.03.2002 Bulletin 2002/12

(51) Int Cl.7: B65G 17/32, B65G 47/90,
B07C 5/16, B65G 47/68

(21) Application number: 01203445.0

(22) Date of filing: 11.09.2001

(84) Designated Contracting States:
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE TR
Designated Extension States:
AL LT LV MK RO SI

(30) Priority: 14.09.2000 NL 1016186
20.10.2000 NL 1016453

(71) Applicant: De Greef's Wagen-,
Carrosserie- en Machinebouw B.V.
4196 AM Tricht (NL)

(72) Inventor: De Greef, Jacobus Hendrik
4181 BM Waardenburg (NL)

(74) Representative:
Land, Addick Adrianus Gosling et al
Arnold & Sledsma,
Advocaten en Octrooigemachtigden,
Sweelinckplein 1
2517 GK Den Haag (NL)

(54) Apparatus and method for conveying and/or transferring fruits

(57) The present invention relates to an apparatus for conveying and/or transferring relatively vulnerable products, such as fruits, wherein the fruits are held in grippers while being conveyed and transferred, wherein

said grippers comprise a first gripper portion and a second gripper portion, which are movable over sliding elements substantially in the direction in which the gripping force is exerted on the products.

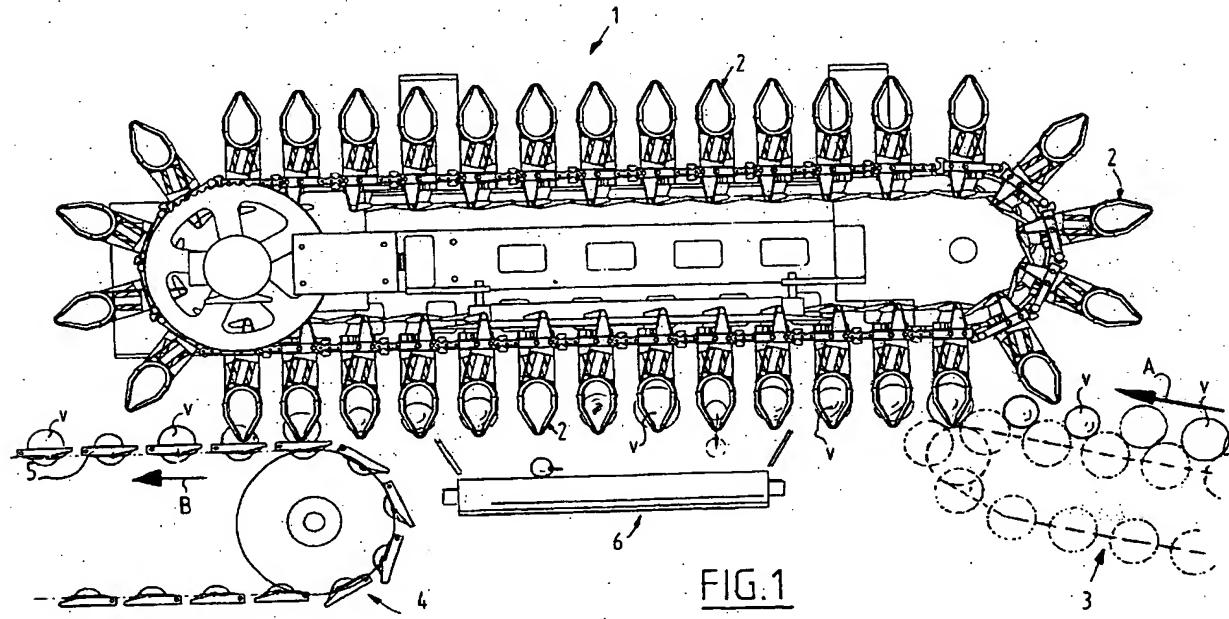


FIG.1

EP 1 188 692 A2

Description

[0001] The sorting of fruits takes place at increasingly higher speeds, for example at speeds of 7 - 15 fruits per second. Because of said high speeds, the fruits may be damaged upon being transferred from a first conveyor to a second conveyor, which is undesirable.

[0002] From European patent application EP A 0 687 508 there is known a conveyor which is fitted with grippers. Said grippers are used for conveying products to individual stations. Consequently, a relatively large number of gripping hands are required. Furthermore, flexible arms are used on the grippers so as to be able to engage fruits of varying diameter.

[0003] The present invention provides an apparatus for conveying and/or transferring relatively vulnerable products, such as fruits, wherein the fruits are held in grippers while being conveyed and transferred, wherein said grippers comprise a first gripper portion and a second gripper portion, which are movable over sliding elements substantially in the direction in which the gripping force is exerted on the products.

[0004] Furthermore, the present invention provides an apparatus for transferring vulnerable products, such as fruits, from a supply conveyor to a discharge conveyor, wherein said fruits are held in grippers and wherein the said products that are present in said grippers are weighed while being transferred.

[0005] Preferably, a pivoted suspension on the outer side is used, so that it is possible to use a three-point support so as enable a stable weighing process. Furthermore, the bearing sliding surfaces for said three-point weighing are preferably spaced apart as far as possible.

[0006] The present invention also provides a method for conveying and discharging one or more fruits, wherein:

- the fruits are separated from each other in a singling device;
- the individual fruits are taken out of said singling device by means of grippers and transferred to a conveyor fitted with product carriers, during which transfer the individual fruits are weighed; and
- wherein said fruits are discharged from the conveyor with the product carriers, by tilting said product carriers and causing the fruits to move past a flexible element.

[0007] The above method enables a relatively simple construction of the appropriate apparatus, in particular of the conveyor fitted with product carriers, since weighing takes place in the grippers.

[0008] With a view to obtaining a calibration hallmark, it is important that the apparatus be standardized, that is, that a fixed number of parts and a fixed length of (a weighing portion of) the apparatus are used.

[0009] It is possible, however, to set a different track

width, for example by adjusting the pin length, for example for fruits ranging in a diameter between 22 mm and 250 mm.

[0010] In the past, the applicant furthermore marketed an apparatus wherein fruits were sorted and discharged at specific positions in dependence on measured quantities, such as weight, size, colour and the like. A slab of a flexible material was used during the discharge of the fruits so as to reduce the velocity thereof. Since the fruits were weighed in the fruit carriers, said slab was in fact detached from the cup or fruit carrier and it was fitted near the front side thereof - seen in the conveying direction. As a result, said slab had a considerable length of about 30 cm, for example, which caused quite some inconvenience in the device when discharging took place into water channels, because the long slabs scooped up (a great deal of) water. In dry discharging situations, the long slab had an abrasive effect on the fruits, which had a negative effect on the quality of said fruits.

[0011] The present invention furthermore provides an apparatus for conveying and discharging vulnerable products, such as fruits, comprising:

- product carriers that can be moved in the conveying direction;
- tilting means for causing the product carriers to tilt at a specific conveying position, so as to discharge the product from the product carrier in rearward direction, seen in the conveying direction, at said conveying position;
- wherein a product carrier is provided laterally of a conveying element, wherein the product carrier can be returned to the conveying position after the fruit has been discharged, and wherein a flexible element is disposed on the rear side of the product carrier for the purpose of discharging the product from the product carrier in a controlled manner.

[0012] The apparatus according to the present invention has been optimized for conveying and discharging fruits, both in the situation in which the products are carried off without water being used and in the situation wherein water channels are used. With the apparatus according to the invention, the weighing process has preferably taken place already, so that it is possible to attach a much shorter slab, for example a slab having a length of 15 cm, to the rear edge.

[0013] The apparatus according to the present invention does not produce much noise, not even at high speeds. The present invention makes it possible to convey more than five fruits (such as apples) per second, for example 7 - 9 fruits per second, wherein the construction of the apparatus and the controlled discharging speed prevent vulnerable fruits being damaged. Preferably, the fruits are placed into the carriers by grippers, as a result of which the quality, for example of apples, remains ensured, even at the aforesaid high speeds.

[0014] In one preferred embodiment, each product

carrier is furthermore provided with a snap mechanism for discharging the fruits in a reliable manner and pushing the product carrier back into the conveying position and securing it in said position as soon as possible after a product has been discharged, so that the slab need not drag over next products and will not scoop water in the situation wherein water is used.

[0015] In another preferred embodiment, a product carrier is approximately S-shaped in section, seen in the conveying direction, which has appeared to be the most advantageous shape for various types of fruits having varying dimensions. The fruit is properly engaged (on the convex surface thereof), using the lowest possible pressure forces, whilst discharging is facilitated.

[0016] In order to enable the gripping hands to engage properly, the product carrier has an approximately S-shaped profile in cross-sectional view as well.

[0017] The present invention furthermore provides a method for conveying and discharging one or more fruits, wherein:

- products carriers containing fruits are moved in the conveying direction;
- the respective product carriers are tilted at specific conveying positions, and the respective fruits are discharged in rearward direction from said product carriers into a water channel; and
- wherein the fruit is slowed down upon being discharged by means of a flexible element which is attached to the rear edge of the product carrier.

[0018] This method, which is preferably carried out in combination with the apparatus according to claims 12 and 13, enables a practical realisation of such an apparatus, since the trouble which the water causes to the chain and other parts of the conveyor is significantly reduced.

[0019] Further advantages, aspects and details of the present invention will be elucidated in the description hereafter, in which reference is made to the appended drawings, wherein:

Figure 1 is a side view of a first preferred embodiment of an apparatus according to the present invention;

Figure 2 is a perspective top plan view of the apparatus of Figure 1;

Figure 3 is a partially broken-away, perspective view of the apparatus of Figures 1 and 2;

Figure 4 is a perspective view of detail IV of Figure 3;

Figure 5 is a side elevation of the detail of Figure 4; Figures 6A and 6B are perspective views of the elements of Figures 4 and 5, respectively showing the open position and the closed position thereof;

Figure 7 is a partially schematic, sectional view of a preferred embodiment of an apparatus according to the present invention;

Figure 8 is a perspective view of detail II in Figure 1; and

Figure 9 is a perspective view of a unit as used in the apparatus according to Figures 1 and 2.

[0020] A device 1 (Figures 1, 2 and 3) comprises a fixed number of gripping hands 2, thirty-four pairs in the present embodiment, for transferring fruits that are being supplied in the direction indicated by arrow A by a first conveyor 3 to a second conveyor 4, wherein the fruits are carried off in fruit carriers 5 in the direction indicated by arrow B. Fruits that are not suitable for direct consumption can be discharged, for example via a third discharging conveyor 6. The device furthermore comprises a frame 7, with chain wheels for endless chains, to which the gripper hands are attached, being suspended therein.

[0021] The open gripper hands 2 are preferably each provided with a cover 41 (see Figure 4) of a soft material so as to enable a proper engagement of the fruits V whilst minimizing the risk of damaging the fruits. As is clearly shown in Figures 2 and 3, device 1 comprises a motor 11 for driving chains 18 with the gripper hands attached thereto, as well as a chain tensioning device 12, which is fitted with a coil spring 19 (Figure 3) and cup springs 14, for the purpose of compensating for changes in the length of the chain as much as possible. A first part 15 of said chain tensioning device 12 (Figure 3) is spaced from a second part 16, which is fixedly-connected to the mounting bracket for the chain wheel 17 to which the driving motor 11 is connected. The cup springs 14, coil spring 19 and the possibility of movement along the sloping surfaces thus enable springing movement of the part 16 comprising the motor and the chain wheels. The first part 15 is fixedly connected to the frame.

[0022] The respective gripper hands 2 that are fitted between chains 18 are movable over pins 43 and 44 (Figure 4) in a direction transversely to the conveying direction. As is also apparent from Figures 5 and 6B, the respective gripper hands are suspended from pins 43, 44. Said pins are fixed to the frame parts 45 and 46, which are connected to the chain in such manner as to be capable of slight pivoting movement, which movement is made possible by knee 47, among other parts.

[0023] Furthermore, connecting pieces 51, see also Figure 5, are provided between successive pairs of gripper hands for the purpose of allowing vertical movements between successive pairs of gripper hands.

[0024] Three supporting surfaces present at the bottom side of frame parts 45 and 46 are each passed over a platform 48 that forms part of a so-called load cell 49 for weighing a fruit which is held by the gripper hands. As the number of gripper hands is limited, it is certainly within the bounds of the possible that in the future a calibration hallmark will be obtained for this accurate manner of weighing products. At present, calibrated weighing generally takes place manually in the final packag-

ing. Since the apparatus according to the present invention comprises a limited number of gripper hands, for example 25 - 100, the cost that is involved can remain within bounds.

[0025] Frame parts 45 and 46 are preferably made of an easily sliding or resilient plastic material. Experiments have furthermore shown that in the case of speeds of up to 15 fruits per second, 10 - 50 msec are available for determining the weight in an accurate and stable manner, which is made possible by the three-point support.

[0026] Gripper hands 2 are movable from an open position as shown in Figure 6A to a closed position as shown in Figure 6B by means of cams 61, which are movable, along with the gripper hands 2, over sliding rods 43 and 44 against the action of a coil spring 62. The supporting parts 45 and 46 for weighing are pivotally connected to chains 8, whilst the knees 47 that are fitted between the two pairs can pivot independently of each other. Parts 45 and 46 are thus pivotally connected to pins 65, which are each fixedly connected to chains 18 so as to ensure independent weighing of the pairs that are positioned adjacently to each.

[0027] With an apparatus 70 (Figure 7) according to the present invention, vulnerable products, such as apples A, are transported by means of fruit carrier 72 to discharging positions, preferably water channels 73 and 74, two of which are shown in Figure 1, whilst in practice dozens of discharging positions are available, at which positions the fruits can be sorted according to size, weight, quality, colour and the like. In Figure 7, housings 75, 76 are indicated highly schematically, in which housings cameras for sorting the fruits A according to colour may be disposed, for example. The fruit carriers 72 are transported by means of endless chains 78, which circulate via chain wheels 79 and 80. If a fruit is to be discharged at discharging location 74, a fruit carrier is released at that location, so that said fruit carrier will tilt about a pin 72 and fruit A will be discharged via a sloping surface 83 and a slab 84 that is attached to fruit carrier 72.

[0028] As is apparent from Figures 8 and 9, a unit 30 consisting of two fruit carriers 72, each fitted with a slab 84, is provided with hook ends 91 and 92 for connecting unit 90 to (and above) chain 78 and to a rail 94 extending below chain 78, respectively. Nose lips 93 ensure the fixation in longitudinal direction with respect to chain 78.

[0029] The fruit carriers are S-shaped in section, both in the conveying direction and in a direction transversely thereto. In practice said S-shaped section has provided to be suitable for various types of fruits. The S-shape in transverse direction enables proper engagement of the fruits present in carriers 72 by the grippers - see for example Dutch patent application no. 1016168 (not pre-published).

[0030] Since the fruit carriers are disposed relatively high with respect to the chain, the fruits can be readily engaged therein and/or be deposited therein, for exam-

ple by means of the aforesaid grippers. The use of grippers makes it possible to increase the velocity of the fruit carriers, whilst the presence of the slab does not result in a greater spacing between the fruit carriers.

5 [0031] Hook ends 95 are present on either side of the product carriers 72, which hook ends are engaged in a snap mechanism 96 in the conveying position, which snap mechanism comprises an operating lever 97 and a springing portion 98, which snap mechanism is preferably integrally formed of plastic material with a carrier and/or a central portion 100 of unit 90.

10 [0032] As is apparent in particular from Figure 8, a guide element 102 is provided near every discharging position, such as the one at water channel 74, which guide element forms a curved track along which the fruit carriers are guided, that is, along the downward flank of the curved track during discharging and along the upward flank after discharging at a preceding discharging position so as to return the fruit carriers to the conveying position. An actuating mechanism 103 is provided near guide element 102 for moving a fruit carrier 72 from the conveying position to the discharging position. Said mechanism 103 comprises an electrically actuated rod 104, which actuates lever 105 upon upward movement, which lever in turn actuates the lever 97 of a respective fruit carrier unit, as a result of which the hook 95 is detached from the snap mechanism 96 and the fruit is carefully discharged as a result of the presence of the downward flank of curved element 102, guide plate 83 and slab 84.

15 [0033] The invention is not restricted to the above-described preferred embodiments thereof; the rights applied for are determined by the claims hereinafter, within the scope of which all kinds of modifications are conceivable.

Claims

- 20 1. Apparatus for conveying and/or transferring relatively vulnerable products, such as fruits, wherein the fruits are held in grippers while being conveyed and transferred, wherein said grippers comprise a first gripper portion and a second gripper portion, which are movable over sliding elements substantially in the direction in which the gripping force is exerted on the products.
- 25 2. Apparatus according to claim 1, wherein said sliding elements are rods, over which said gripper portions are movable.
- 30 3. Apparatus according to claim 1, wherein said gripper portions are provided with cam members for moving said gripper portions together/apart against spring force.
- 35 4. Apparatus for transferring vulnerable products,

such as fruits, from a supply conveyor to a discharge conveyor, wherein said fruits are held in grippers and wherein the said products that are present in said grippers are weighed while being transferred.

5. Apparatus according to claim 4, wherein said grippers are suspended in a frame in such manner as to be capable of slight pivoting movement, whilst on the other hand said grippers comprise contact elements for weighing the same on a weighing device.

6. Apparatus according to claim 5, wherein said contact elements are passed over part of a force measuring device.

7. Apparatus according to any one or more of the preceding claims, which apparatus comprises a chain tensioning device.

8. Apparatus according to any one or more of the preceding claims, wherein said grippers comprise an open frame and a cover enveloping said frame.

9. Method for conveying and/or transferring fruits, using an apparatus according to any one or more of the claims 1 - 8.

10. Grippers apparently suitable for use in an apparatus according to any one or more of the claims 1 - 8 and/or with a method according to claim 9.

11. Method for conveying and discharging one or more fruits, wherein:

- the fruits are separated from each other in a singling device;
- the individual fruits are taken out of said singling device by means of grippers and transferred to a conveyor fitted with product carriers, during which transfer the individual fruits are weighed; and
- wherein said fruits are discharged from the conveyor with the product carriers, by tilting said product carriers and causing the fruits to move past a flexible element.

12. Apparatus for conveying and discharging vulnerable products, such as fruits, comprising:

- product carriers that can be moved in the conveying direction;
- tilting means for causing the product carriers to tilt at a specific conveying position, so as to discharge the product from the product carrier in rearward direction, seen in the conveying direction, at said conveying position;
- wherein a product carrier is provided laterally

of a conveying element, wherein the product carrier can be returned to the conveying position after the fruit has been discharged, and wherein a flexible element is disposed on the rear side of the product carrier for the purpose of discharging the product from the product carrier in a controlled manner.

13. Apparatus according to claim 12, wherein water channels are provided near the discharging position, in which the discharged products are carried off.

14. Apparatus according to claim 12, wherein the products are carried off by means of one or more conveyor belts at the discharging position.

15. Apparatus according to claim 12, 13 or 14, wherein said conveying element is a chain, and wherein a product carrier is provided on either side of said chain.

16. Apparatus according to any one of the claims 12 - 15, wherein a number of chains are interconnected, for example by means of pins.

17. Apparatus according to any one of the preceding claims, wherein said tilting means comprise a locking mechanism for locking said product carrier in the conveying position and releasing said product carrier to enable movement thereof to the discharging position.

18. Apparatus according to claim 17, wherein said locking mechanism includes a snap mechanism.

19. Apparatus according to any one of the preceding claims, wherein a product carrier is approximately S-shaped in section in the conveying direction and/or in a direction transversely thereto.

20. Apparatus according to any one of the preceding claims, wherein a product is placed on a product carrier by means of grippers, during which operation the product is weighed.

21. Method for sorting fruits, wherein an apparatus according to any one of the preceding claims is used.

22. A unit consisting of two interconnected product carriers, locking means for locking/releasing each of said product carriers, and a central portion to be attached to a chain, which central portion extends between said product carriers.

23. Method for conveying and discharging one or more fruits, wherein:

- products carriers containing fruits are moved in the conveying direction;
- the respective product carriers are tilted at specific conveying positions, and the respective fruits are discharged in rearward direction from said product carriers into a water channel; and
- wherein the fruit is slowed down upon being discharged by means of a flexible element which is attached to the rear edge of the product carrier.

5

10

15

20

25

30

35

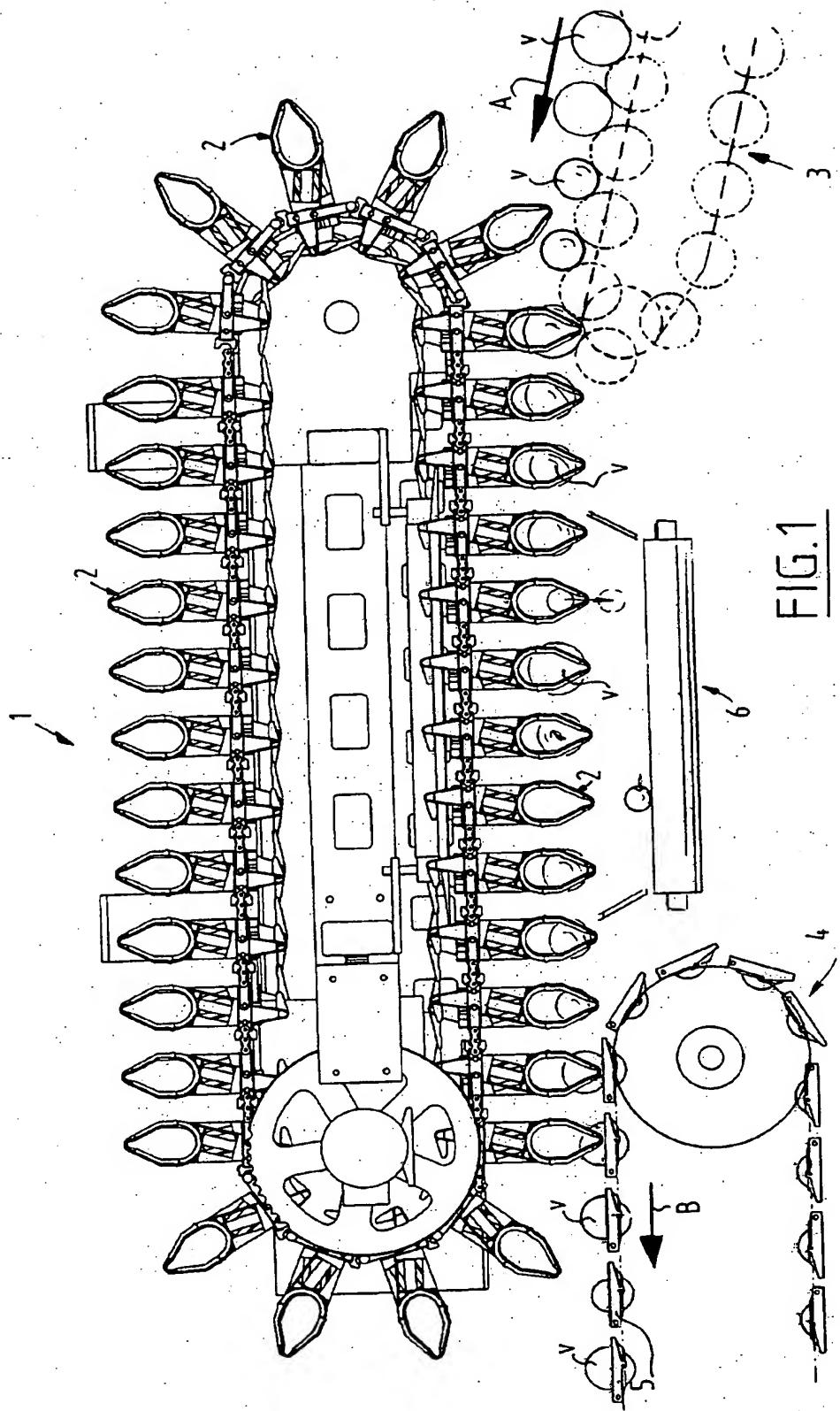
40

45

50

55

6



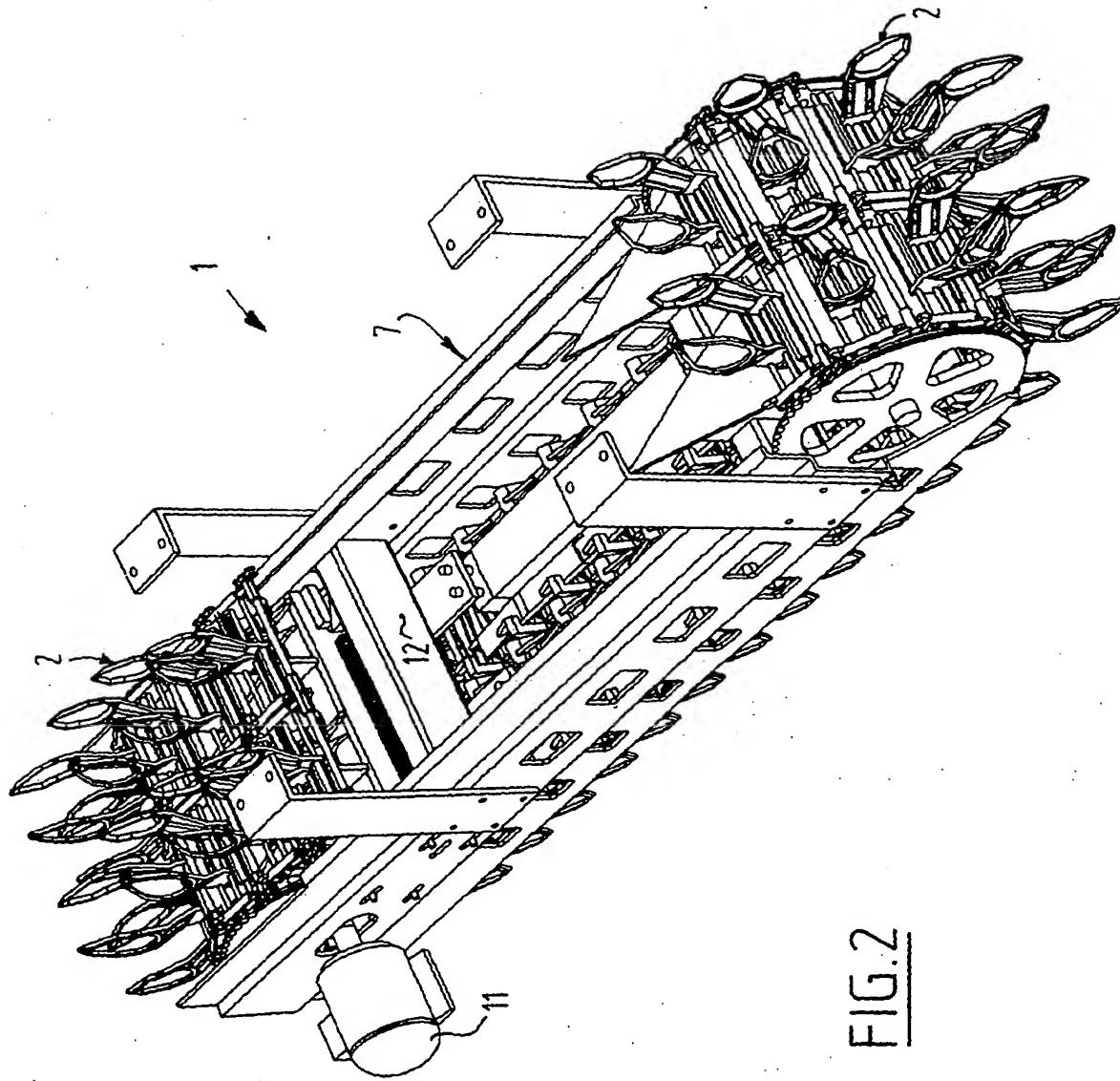
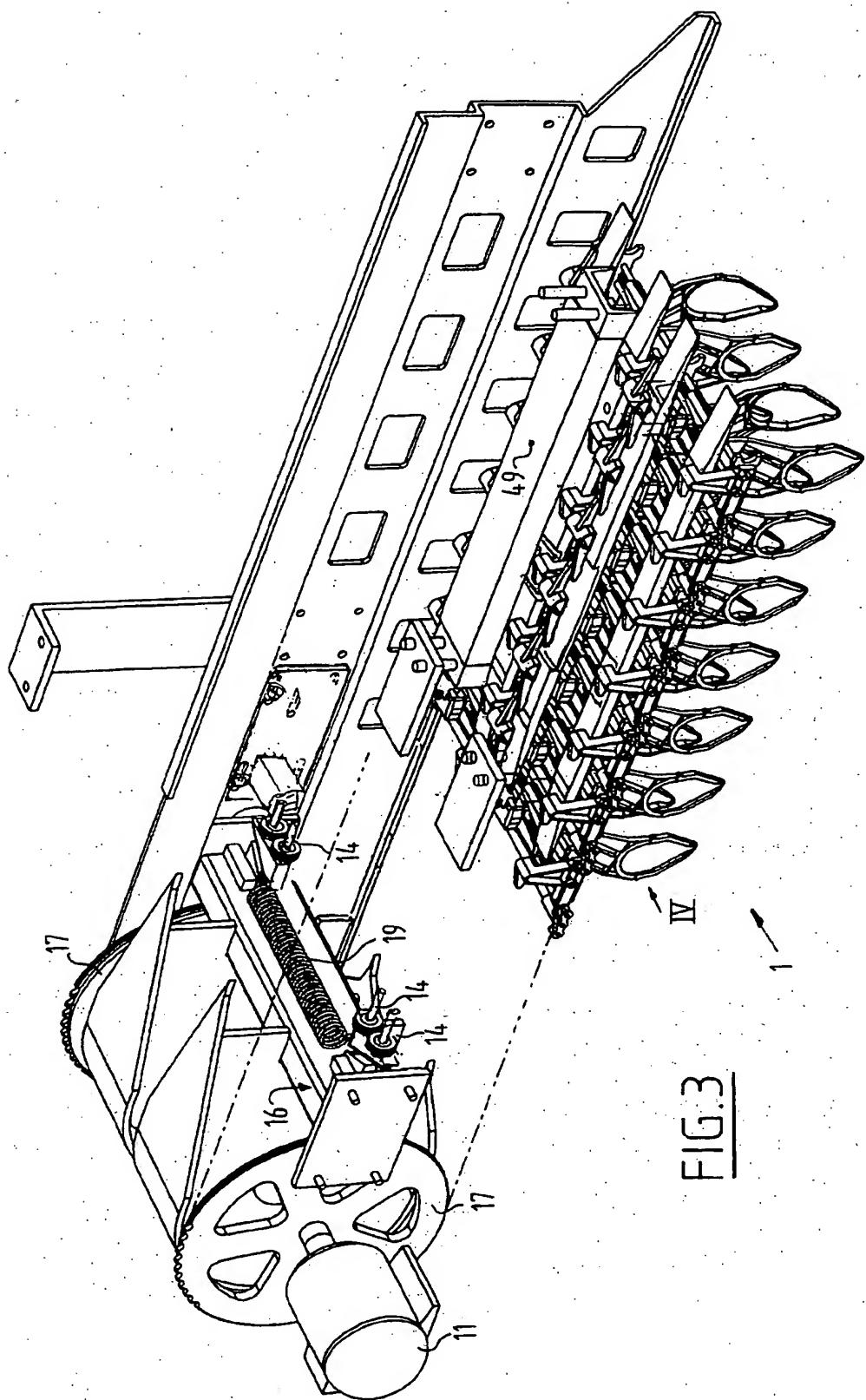
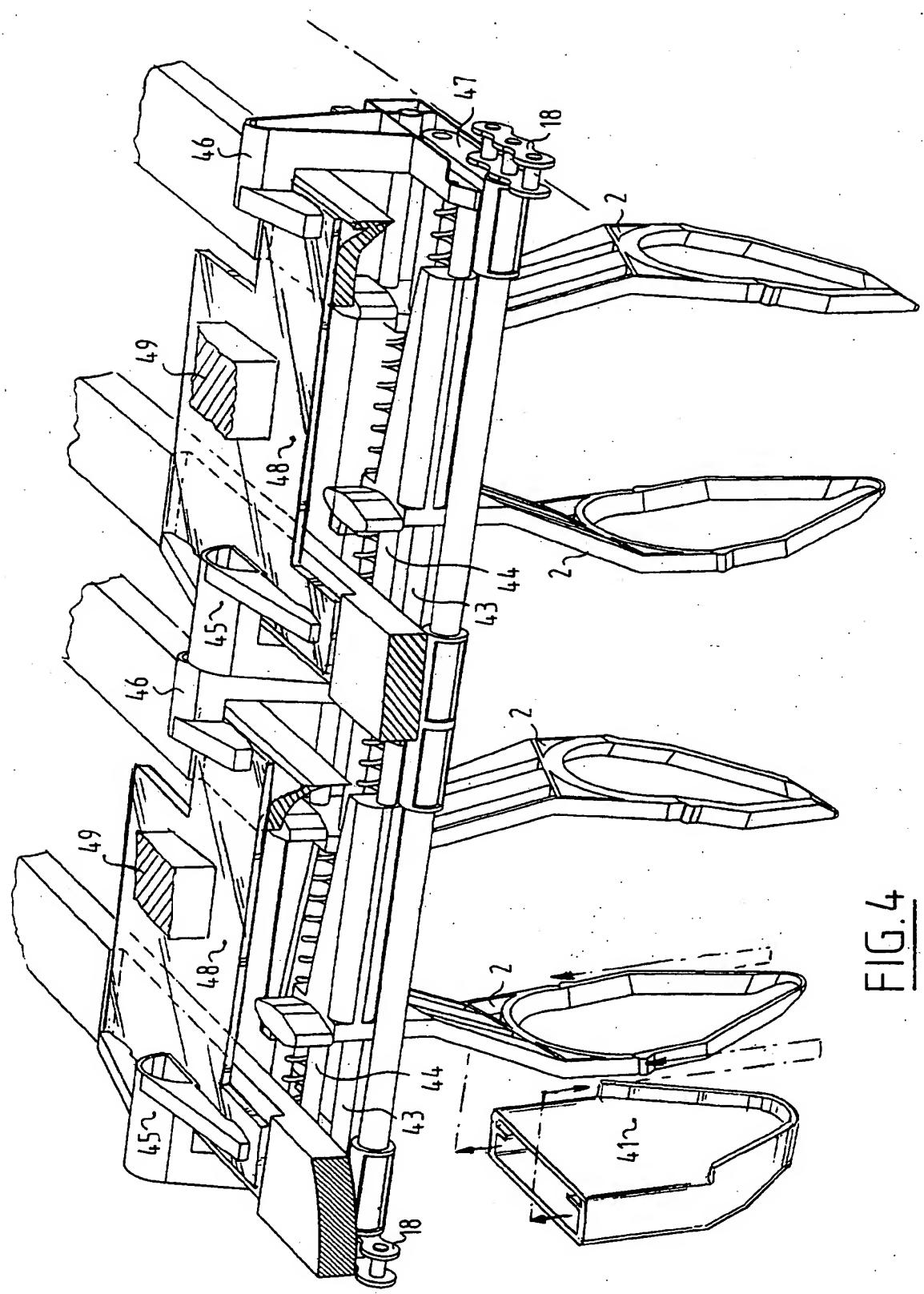
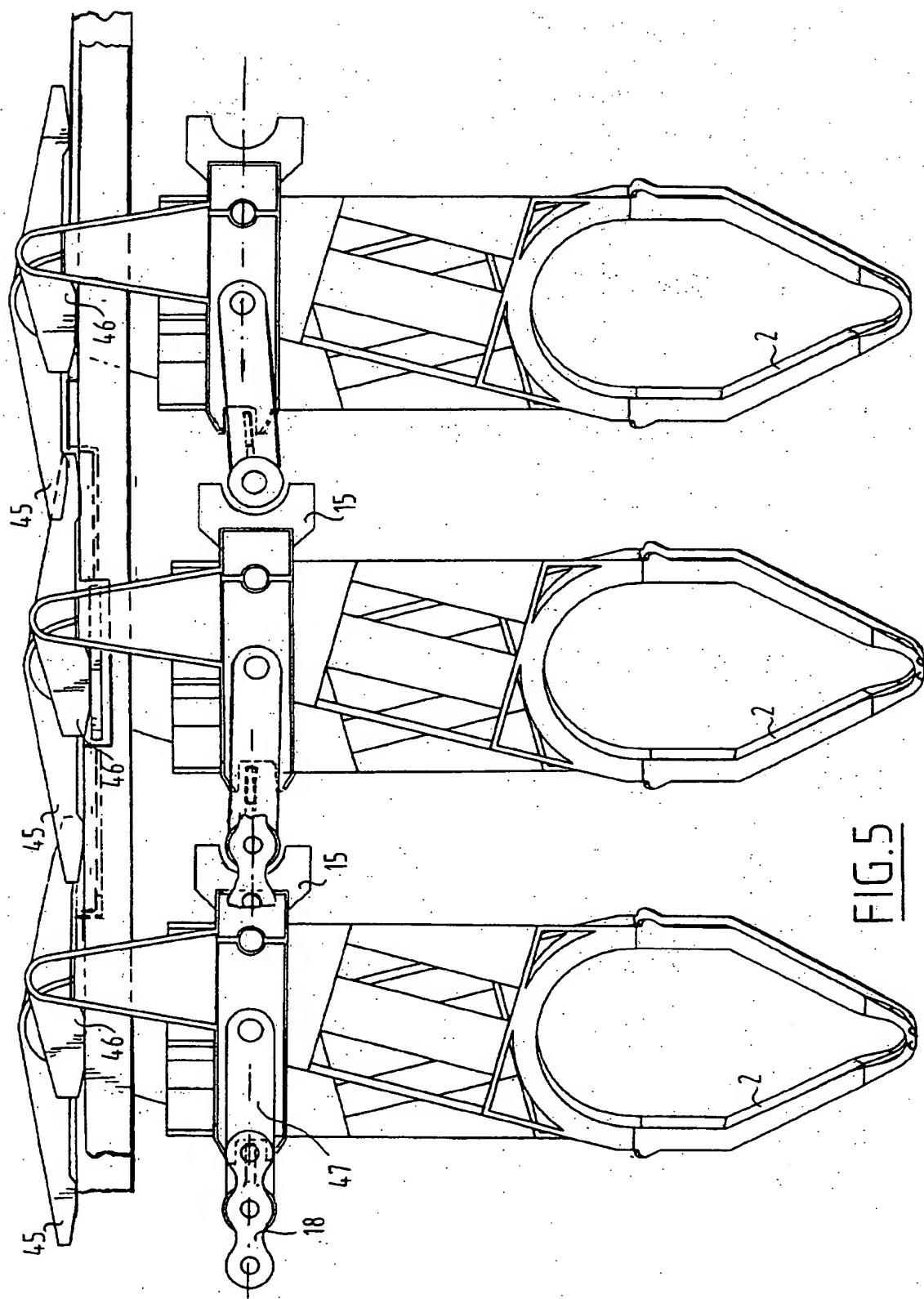


FIG. 2







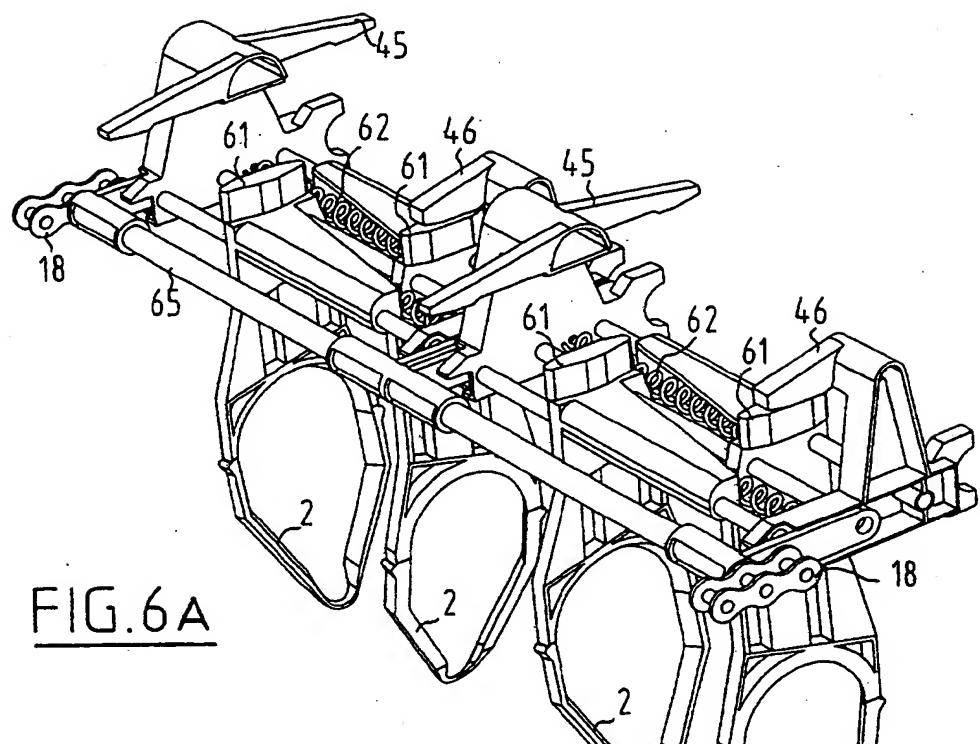


FIG. 6A

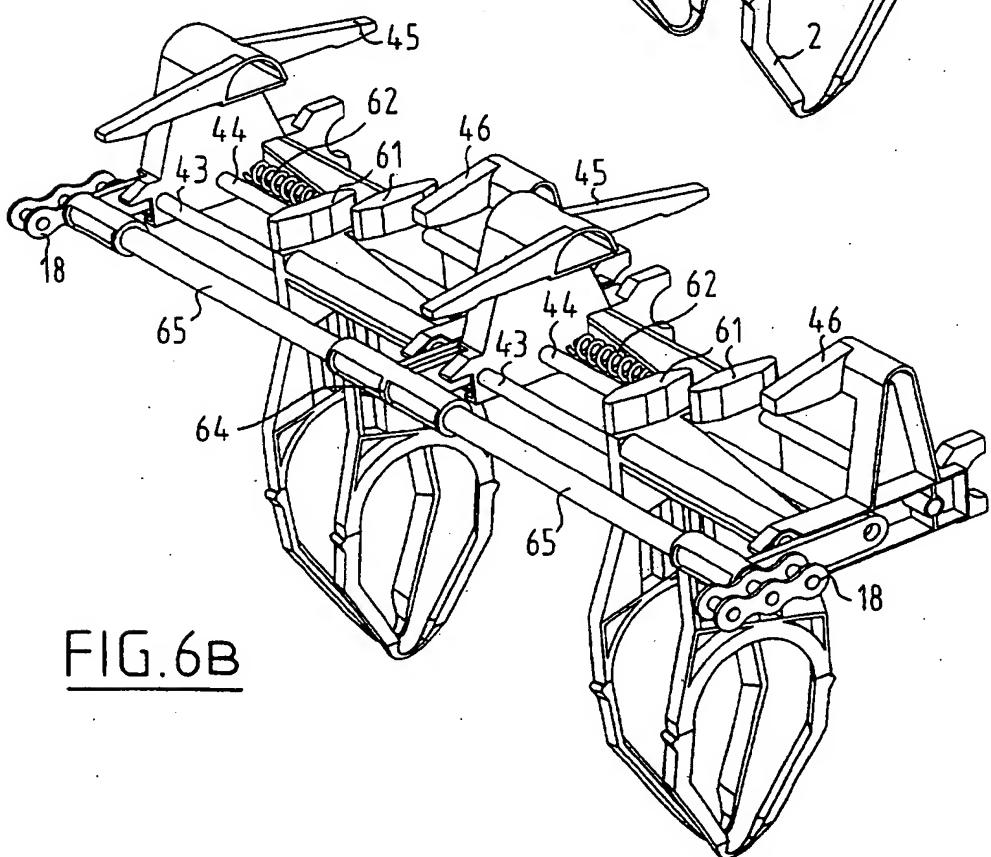


FIG. 6B

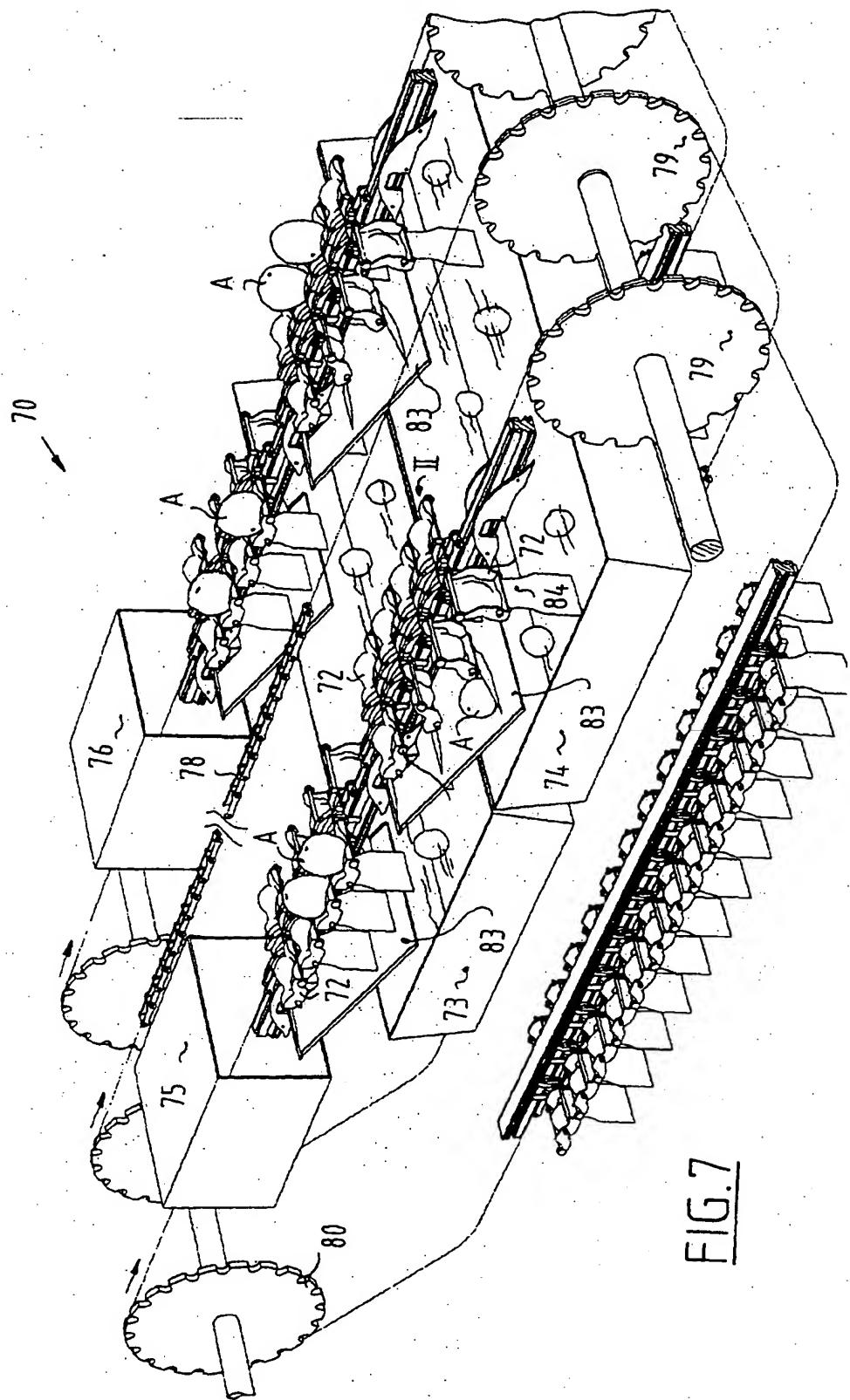
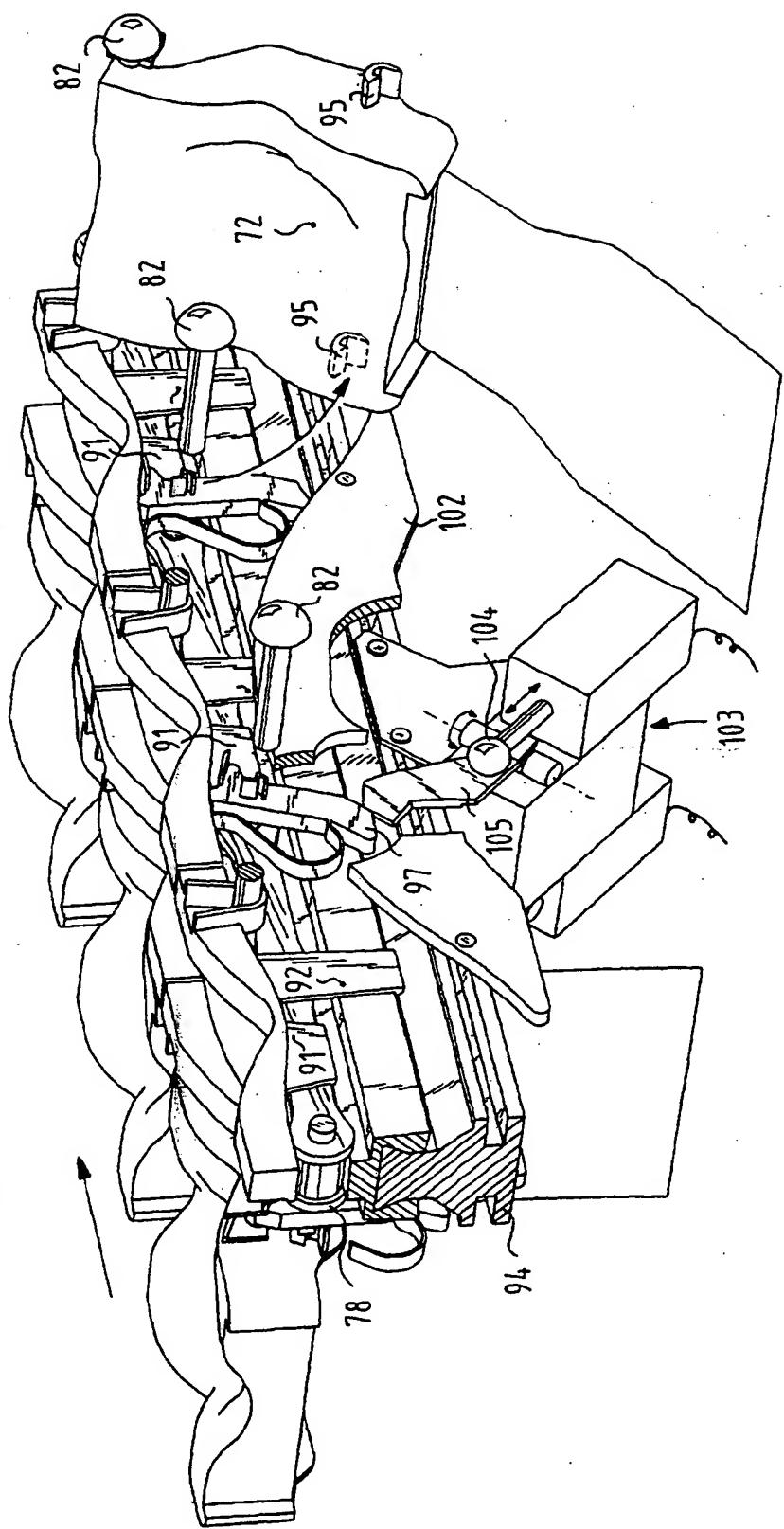
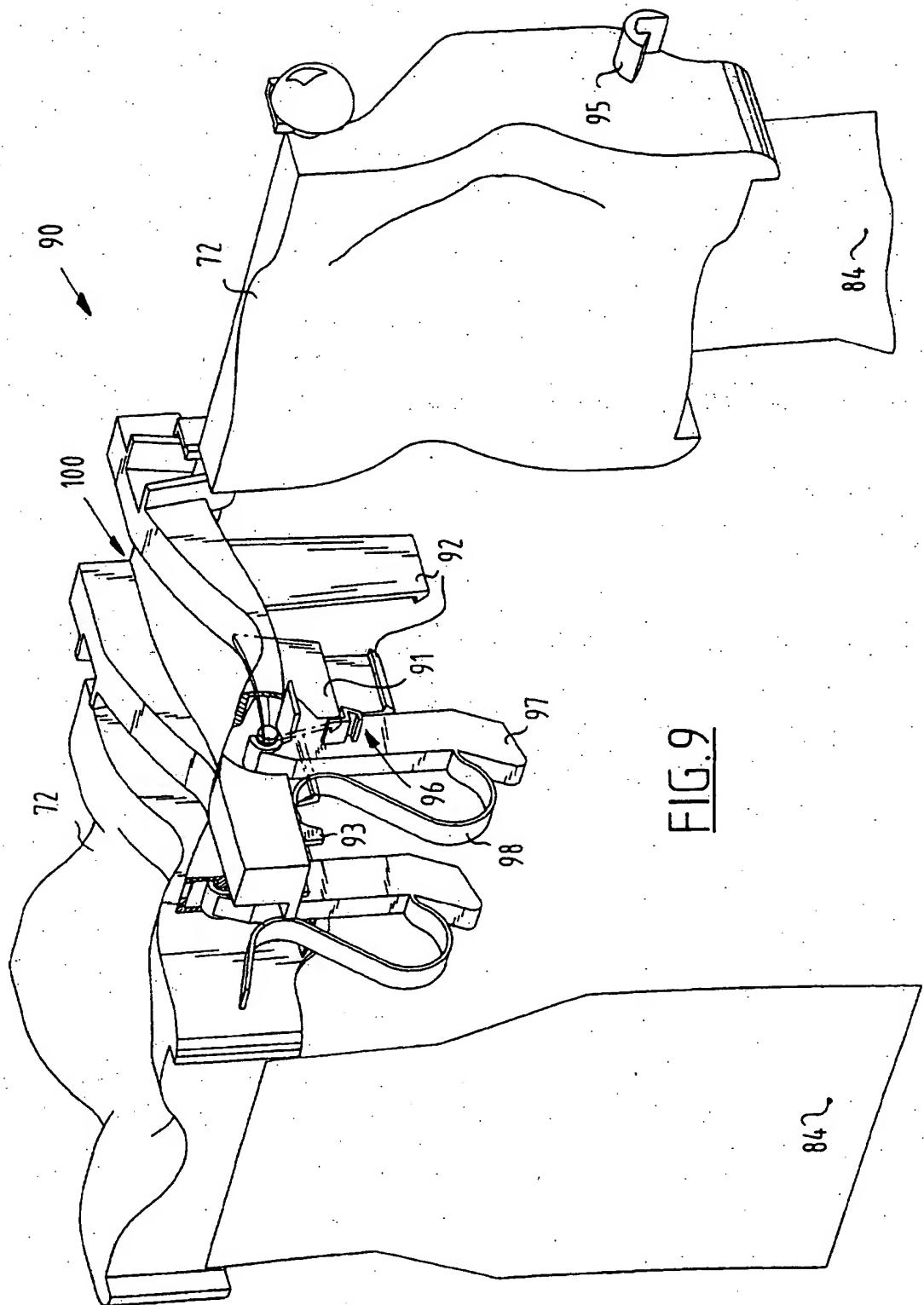


FIG. 7

FIG.8





THIS PAGE BLANK (USPTO)

(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

EP 1 188 692 A3

(12)

EUROPEAN PATENT APPLICATION

(88) Date of publication A3:
03.07.2002 Bulletin 2002/27

(51) Int Cl.7: B65G 17/32, B65G 47/90,
B07C 5/16, B65G 47/68,
B07C 5/22

(43) Date of publication A2:
20.03.2002 Bulletin 2002/12

(21) Application number: 01203445.0

(22) Date of filing: 11.09.2001

(84) Designated Contracting States:
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE TR

Designated Extension States:
AL LT LV MK RO SI

(30) Priority: 14.09.2000 NL 1016186
20.10.2000 NL 1016453

(71) Applicant: De Greet's Wagen-,
Carrosserie- en Machinebouw B.V.
4196 AM Tricht (NL)

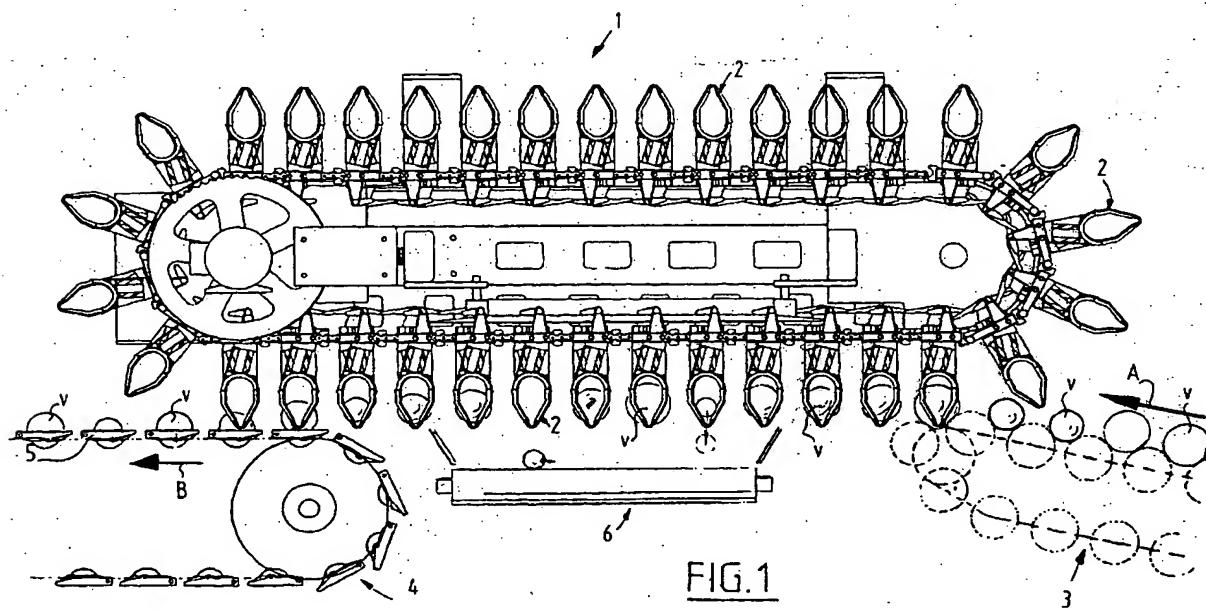
(72) Inventor: De Greet, Jacobus Hendrik
4181 BM Waardenburg (NL)

(74) Representative:
Land, Addick Adrianus Gosling et al
Arnold & Siedsma,
Advocaten en Octrooigemachtigden,
Sweelinckplein 1
2517 GK Den Haag (NL)

(54) Apparatus and method for conveying and/or transferring fruits

(57) The present invention relates to an apparatus for conveying and/or transferring relatively vulnerable products, such as fruits, wherein the fruits are held in grippers while being conveyed and transferred, wherein

said grippers comprise a first gripper portion and a second gripper portion, which are movable over sliding elements substantially in the direction in which the gripping force is exerted on the products.





European Patent
Office

EUROPEAN SEARCH REPORT

Application Number
EP 01 20 3445

DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (IntCl.7)
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	
X	US 3 884 184 A (ARRANDALE ROY S ET AL) 20 May 1975 (1975-05-20) * column 3, paragraphs 3,4 * * column 4, paragraph 1 * Idem	1-3 4,6,9-11	B65G17/32 B65G47/90 B07C5/16 B65G47/68 B07C5/22
D,Y	EP 0 687 508 A (TAS ADRIANUS WILHELMUS) 20 December 1995 (1995-12-20) * column 4, last paragraph * * column 5, paragraph 1 *	4,6,9-11	
X	EP 0 471 401 A (SMIT GERARDUS) 19 February 1992 (1992-02-19) * column 5, paragraph 2 *	1-3	
A	WO 97 42112 A (ARKEL JAN MARINUS VAN VOS MARINUS DE (NL); GREEF JACOB HENDRIK DE) 13 November 1997 (1997-11-13) * the whole document *	1,4,8-11	
X	US 1 710 199 A (WHITE EDWARD A) 23 April 1929 (1929-04-23) * the whole document *	12,23	TECHNICAL FIELDS SEARCHED (IntCl.7)
A	US 4 411 366 A (DE GREEF JAN A) 25 October 1983 (1983-10-25) * column 5, last paragraph - column 6, paragraph 1; figure 10 *	12, 14-18, 20-23	B65G B07C
A	US 4 299 326 A (ULCH BRYAN D) 10 November 1981 (1981-11-10) * column 6, line 11 - line 30; figures 1,13 *	22	
A	US 4 823 934 A (LEMAIRE DIDIER ET AL) 25 April 1989 (1989-04-25)		
The present search report has been drawn up for all claims			
Place of search	Date of completion of the search	Examiner	
THE HAGUE	8 May 2002	Beernaert, J	
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone	T : theory or principle underlying the invention		
Y : particularly relevant if combined with another document of the same category	E : earlier patent document, but published on, or after the filing date		
A : technological background	D : document cited in the application		
O : non-written disclosure	L : document cited for other reasons		
F : intermediate document	G : member of the same patent family, corresponding document		

**CLAIMS INCURRING FEES**

The present European patent application comprised at the time of filing more than ten claims.

Only part of the claims have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims and for those claims for which claims fees have been paid, namely claim(s):

No claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims.

LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirements of unity of invention and relates to several inventions or groups of inventions, namely:

see sheet B

All further search fees have been paid within the fixed time limit. The present European search report has been drawn up for all claims.

As all searchable claims could be searched without effort justifying an additional fee, the Search Division did not invite payment of any additional fee.

Only part of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the inventions in respect of which search fees have been paid, namely claims:

None of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the invention first mentioned in the claims, namely claims:



European Patent
Office

LACK OF UNITY OF INVENTION
SHEET B

Application Number
EP 01 20 3445

The Search Division considers that the present European patent application does not comply with the requirements of unity of invention and relates to several inventions or groups of inventions, namely:

1. Claims: 1-11

apparatus and method for manipulating vulnerable products by
grippers

2. Claims: 12-21,23

apparatus and method for manipulating vulnerable products by
tilting carriers

3. Claim : 22

unit consisting of two interconnected carriers

ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.

EP 01 20 3445

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on. The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

08-05-2002

Patent document cited in search report		Publication date		Patent family member(s)	Publication date
US 3884184	A	20-05-1975	US	3955824 A	11-05-1976
			AU	456100 B	12-12-1974
			AU	5828973 A	12-12-1974
			BE	802741 A1	16-11-1973
			CA	988450 A1	04-05-1976
			DE	2337330 A1	14-02-1974
			FR	2193764 A1	22-02-1974
			GB	1424283 A	11-02-1976
			IT	1003108 B	10-06-1976
			JP	49059814 A	11-06-1974
			SE	401917 B	05-06-1978
EP 0687508	A	20-12-1995	JP	9165011 A	24-06-1997
			NL	9400969 A	02-01-1996
			EP	0687508 A1	20-12-1995
			US	5703332 A	30-12-1997
			ZA	9504926 A	15-02-1996
			DE	69519601 D1	18-01-2001
			DE	69519601 T2	21-06-2001
			ES	2155109 T3	01-05-2001
EP 0471401	A	19-02-1992	NL	9001767 A	02-03-1992
			EP	0471401 A2	19-02-1992
WO 9742112	A	13-11-1997	NL	1003057 C2	10-11-1997
			EP	1009695 A1	21-06-2000
			WO	9742112 A1	13-11-1997
			US	6234300 B1	22-05-2001
US 1710199	A	23-04-1929	NONE		
US 4411366	A	25-10-1983	NL	8001900 A	02-11-1981
			DE	3165330 D1	13-09-1984
			EP	0037142 A1	07-10-1981
			ES	500841 D0	01-01-1982
			ES	8201855 A1	01-04-1982
US 4299326	A	10-11-1981	EP	0028527 A1	13-05-1981
			ES	496554 D0	16-11-1981
			ES	8200826 A1	16-02-1982
			JP	56081172 A	02-07-1981
US 4823934	A	25-04-1989	FR	2607479 A1	03-06-1988
			AT	57670 T	15-11-1990
			DE	3765761 D1	29-11-1990
			DE	273798 T1	15-12-1988

For more details about this annex : see Official Journal of the European Patent Office, No. 12/82

ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.

EP 01 20 3445

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

08-05-2002

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 4823934	A	EP 0273798 A2	06-07-1988
		GR 89300007 T1	29-09-1989
		GR 3001148 T3	25-06-1992